April-15-13 2:39:57 PM

Required Date: 4/29/13

Item ID:

D3189-1

Accept

N900040100

Run

Setup Start *NS1*

Revision ID: Item Name:

Chafing Shield(send DSI9629 with spares)

Start Date:

4/15/13

Start Qty: 20.00 Req'd Qty: 20.00 *20*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ Date: 13-04-15 Tooling:

____ Date:

QC: ____ Date: ___ SPC (Y/N):

_____ Date: ____

Stop

										/
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3189	C									
100	The state of the s		0.00							
100	SHEAR									Tm. 3 :
Waterjet	Memo		0.00					O		J1113-4-16
FLOW CNC Waterjet										
	1-Cut a	s per Dwg								

Dwg Rev: C

2-Deburr if necessary

103

QC2- Inspect parts off machine FAI/FAIB

0.00

102

QC

Memo

0.00

Quality Control

											DQA:	Dat	le: _	
NCR: Y	es .	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE	QA Closed:	 Dat	te:	
Work Orde	nė.					DISPOSITION				AGAINST D	EPARTMENT			
Part No. NCR No.				Scrap Machir Use-as-is Thermoform			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	mall Fab Prod. Eng. Coor Finishing Rec/Store/Packaging			Engineering Quality Other		
Root					Descri	ption of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	<u> </u>	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY					
Landi		e ar Bending				General Bend		Grain			Ovalized			Pressure/Forced
	Ц	Centre No Cracks		ntric to	o/s	BOM/Route Broken/Damaged		t ·	on Incomplete		Over/Under Part Incorre	ct		Temperature/Cure Weld
,	☐ [°]	Crushed/ Cuffs	-			Burrs Contamination	-	Mainte		Unclear	Part Lost/M Part Moved	•		Wrong Stock Pulled
	├	leat Trea		Tube		Countersink Cut Too Short	·	Mislabe Misread		L	Positioned \ Power Loss/			Other
		Ripples in	Bend			Drill Holes	Г	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

April-15-13 2:39:57 PM

Required Date: 4/29/13

Item ID: **Revision ID:**

D3189-1

Accept

N900040100

Setup Start

Item Name: **Start Date:**

4/15/13

Start Qty: 20.00 Req'd Qty: 20.00

Chafing Shield(send DSI9629 with spares)

Cust Item ID:

Customer:

Reference:

Approvals:

Tooling:

Date:

Process Plan: Date:

QC: _____ Date: ____ SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 105

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Run

Reject

Insp. Number Stamp

105

QC Quality Control

Memo

0.00

110

110 Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Memo

120

120

Quality Control

QC5- Inspect part completeness to step on W/O

1- Roll as per Dwg D3189

												DQA:	υ	ate:	
NCR: Y	'es /	No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		QA Closed:		ate:	
						DISPOSITION				AGAINST D					
Work Orde	er:					Rework	7		Skid-tube	Crosstube	7		Water Je	t□	Engineering
Part N	lo					Scrap]		Machining	Small Fab]		d. Eng. Coor	-	Quality
NCR N	lo				- 	Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplie	_	Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desc	ription	1	Date	Verification	<u>on</u>	QC Inspector
Doc/Data	_						1								
Equip/Tooling	_														
Operator															
Material	_								*						
Setup															
Other	_														
Process	_							•			١				
Supplier															
Training											١				
Unapproved															
							AUI	LT CATE	GORY						
Landir	ng Gea	ır			_	General	_	-		_	_				1
	Be	ending				Bend	L	Grain			┥.	Ovalized		\perp	Pressure/Forced
	Ce	ntre No	t Concer	itric to	o/s	BOM/Route	_	Hardwa		_	┥.	Over/Under		L	Temperature/Cure
·	Cr	acks				Broken/Damaged		Inspecti	on Incomplete		4	Part Incorrec	:t	L	Weld
	Cr	ushed/0	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	4	Part Lost/Mi	ssing	L	Wrong Stock Pulled
	cı	ıffs				Contamination	L	Mainte	nance	L_	4	Part Moved			
	Н€	eat Trea	t			Countersink		Mislabe	led	L.		Positioned W	/rong	_	•
	ln	spection	Strip in	Tube		Cut Too Short		Misread	I		ال	Power Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-15-13 2:39:5" PM

Item ID:

D3189-1

4/15/13

Accept

N900040100

Setup Start *NS1*

Revision ID:

Start Date:

Item Name:

Chafing Shield(send DSI9629 with spares)

Cust Item ID:

Required Date: 4/29/13

Start Qty: 20.00 Req'd Qty: 20.00

20

Customer:

Tool ID

Reference:

Approvals:

Process Plan: ____ Date:

Operation

Description

Tooling:

Date:

Run

_____ Date:____ SPC (Y/N):

Date: ____

Tool # Plan

Code

Stop

Number Stamp

Work Center ID 130

Sequence ID/

130

Packaging Packaging

Memo

Identify as per dwg & Stock Location: L653

QC21- Final Inspection - Work Order Release

Run Hours

0.00

0.00

Set Up/

Accept

Qty

Reject

Qty

Reject

21 6 0 Al

Insp.

140

140

Quality Control

QC

Memo

0.00

0.00

13-04-29 MF 13-4-29

										DQA:	Date:		
NCR: Yes	/ No				WORK ORDER NON-C	ON	IFORM	MANCE / UP		QA Closed:	Date:		
Work Order:	· · · · · · · · · · · · · · · · · · ·				DISPOSITION	SPOSITION AGAINST DI				EPARTMENT/PROCESS			
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab			Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering . Quality Other	
Root				Descri	otion of work order update	lr	nitial	Act	tion	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other					J								

			FAU	LT CATEGORY			
Landing	Gear	General		_		_	·
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	L	Part Moved	
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing	[Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

Process
Supplier
Training
Unapproved

Work Order ID: 99911

99911

Parent Item:

D3189-1

D3189-1

Parent Item Name: Chafing Shield(send DSI9629 with spares)

Start Date: 4/15/13

Required Date: 4/29/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	0.0000	0.32	6 .7368 42			
M304S250	GA								**	6.8	•		Jm3-4/16

M304520GA (0.021')

DQA:	Date:	
		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	-			•			-		QA Closed:	Date:	
Work Orde	/· ·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	*				Rework Scrap Use-as-is	The	Skid-tube Machining	Crosstube Small Fab Finishing	⊸i	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update] ''''	Large Fab	Composite]	Supplier	
Root				Descr	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator [
Material [İ				
Setup]									·
Other											
Process		1									
Supplier											
Training							ŀ			1	
Jnapproved		ļ								<u></u>	
					F.	AULT CAT	EGORY				
Landin	g Gear				General				_	-	_
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardv	/are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Trea	at			Countersink	Mislal	peled		Positioned V	Vrong	- -
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offset					
	Torque W	/aves in B	xtrusior	۱ [Drawing	Out o	f Calibration				
	Turning S	equence			Finish	Out o	Sequence				
Г	Wave/Tw	ist in Tub	ne .		Folio	Outsid	le Dimensions				ć.

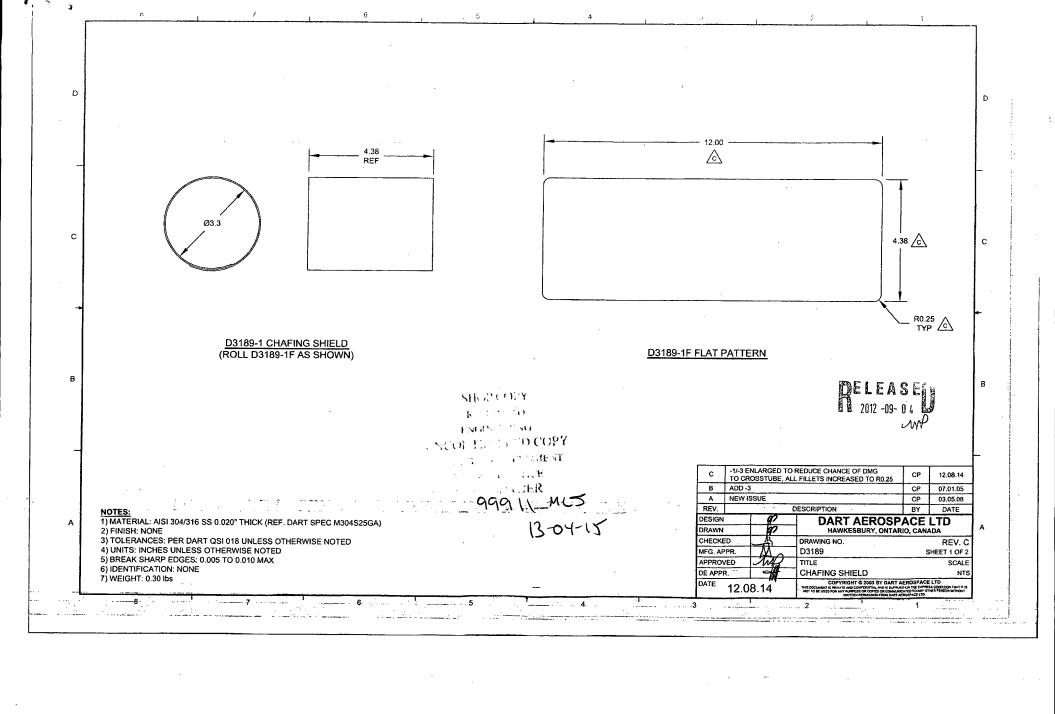
DART AEROSPACE LTD	Work Order:	99911
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189 Rev: C		Page 1 of 1

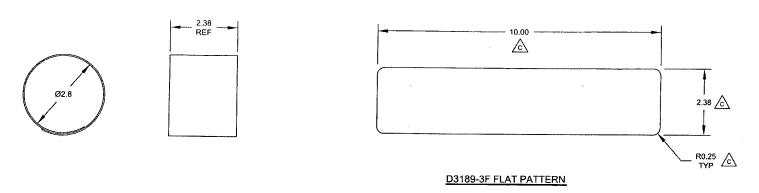
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.38	+/-0.030	4.382	-		ν	Jemoi
12.00	+/-0.030	13.003,	_		V	Ilmoso Pradusor
0.020	+/-0.010	0.031,	_		V	
•	·				54	
					24	
					,	
					A rri	
					.7%	
						• •
·					1.17	
					,	
					•	-
					7	

Measured by: JM	Audited by: 5MD	Preliminary Approval:
Date: 13-4-16	Date: 159/0	Date:

Rev	Date	Change	Revised	l by	Approved
Α	11.06.21	New Issue	KJ	\wedge	2//
В.	12.09.26	Dimensions updated per Dwg Rev C	KJ 🤊	*	(11)
				7 7 -	7





<u>D3189-3 CHAFING SHIELD</u> (ROLL D3189-3F AS SHOWN)

Α

NOTES: 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)

1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.13 lbs

DESIGN	P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	9		
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	140	D3189	SHEET 2 OF 2
APPROVED	July.	TITLE	SCALE
DE APPR.	#	CHAFING SHIELD	NTS
DATE 12.08.14		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS RECENTED AND CONFIDENCE OF A SEPALAGE OF THE SEPALAGE CONFIDENCE THAT IT IS NOT TO BE UND FROM ANY INTERPREPARAGE FOR CONFIDENCE THAT IT IS NOT TO BE UND FROM ANY INTERPREPARAGE FOR CONFIDENCE TO.	